

Date: Wednesday, 10/31/2007 3:26:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number : 35477	
Estimate Number : 10832	
P.O. Number :	Part Number : D29322
This Issue : 10/31/2007 S.O. No. :	Drawing Number : D2932 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34064	Material :
Written By : <u> </u>	Due Date : 11/30/2007 Qty: 6 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: B 00-06.26 New DWG rev (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0X6.25X7.88

Grain Along Long 7.88 Length

Batch No: 3 34873

DTP 08/03/16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

DTP 08/03/16 / SF 08/03/18

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SF 08/03/24

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

DTP 08/03/16 / SF 08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 35477

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

FR 08/03/26

⑥

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-03-26

⑥

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR 0803-27

⑥

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

LS

FR

08/03/27

⑥

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST428*

AS 08/03/27

⑥

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



mf

08-03-27

6

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35477
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.123	0.122	0.122		
B	0.100	0.140		0.122	0.120	0.120	0.120		
C	0.100	0.140		0.121	0.120	0.120	0.120		
D	0.210	0.230		0.2275	0.219	0.220	0.221		
E	1.245	1.255		1.248	1.2485	1.248	1.250		
F	1.245	1.255		1.2485	1.249	1.2485	1.250		
G	2.495	2.505		2.501	2.499	2.499	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.578	1.575		
J	2.495	2.505		2.500	2.499	2.499	2.499		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.314	0.314	0.314	3/3		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.1125	0.114	0.1155	0.117		
O	0.540	0.560		0.5485	0.550	0.550	0.549		
P	0.490	0.510		0.502	0.502	0.5015	.500		
Q	3.715	3.725		3.718	3.719	3.719	3.718		
R	2.470	2.510		2.493	2.493	2.494	2.494		
S	0.240	0.270		0.259	0.263	0.264	0.26		
T	0.100	0.180		0.130	0.132	0.135	.135		
U	1.625	1.635		1.629	1.629	1.630	1.629		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.125	1.145		1.1338	1.130	1.1315	1.1326		
Y	1.565	1.585		1.572	1.569	1.5705	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DJP
Date:	08/03/17

Audited by:	ml
Date:	08/03/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	35477
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

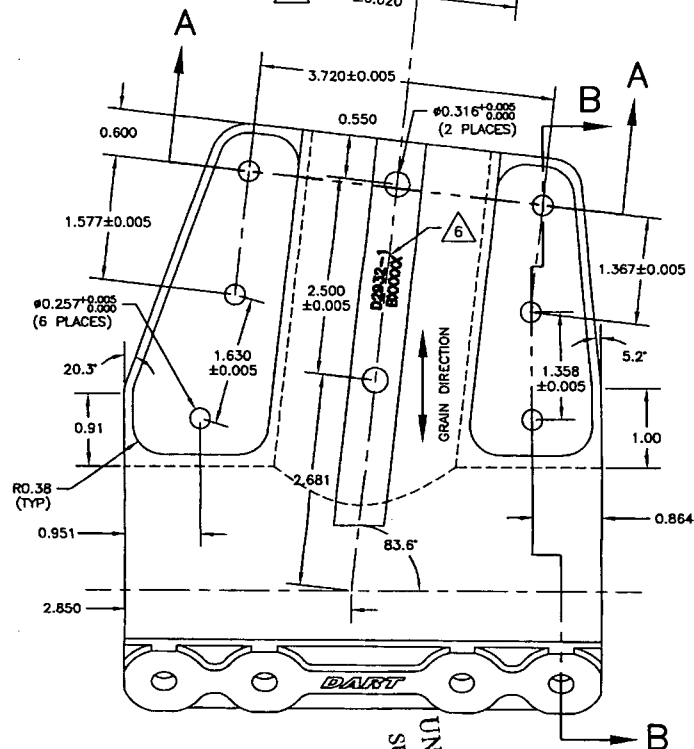
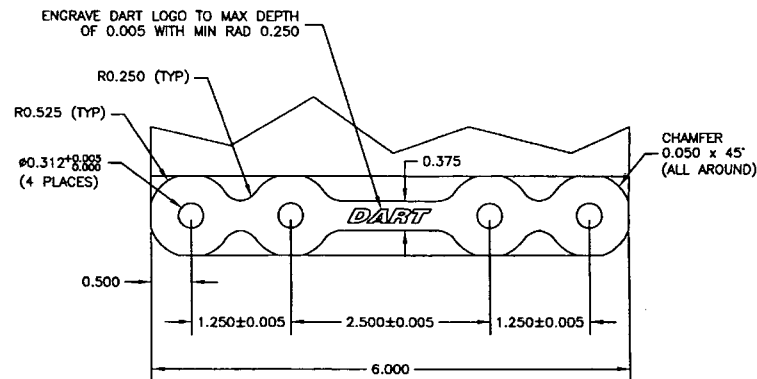
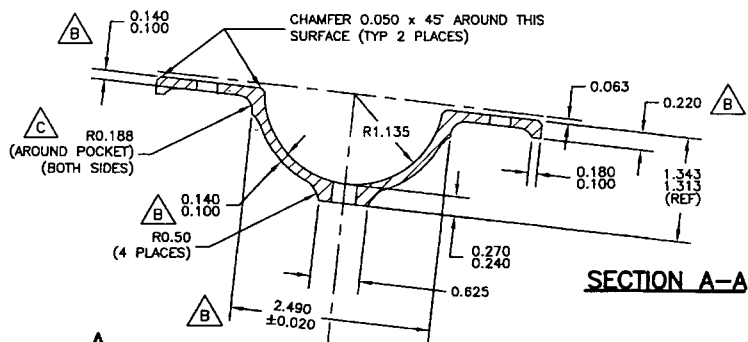
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.100	0.140		.123	.123				
B	0.100	0.140		.124	.124				
C	0.100	0.140		.117	.117				
D	0.210	0.230		0.221	0.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.498	2.499				
K	0.257	0.262		0.259	0.259				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.237	.237				
N	0.100	0.140		0.116	0.116				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.501	.501				
Q	3.715	3.725		3.719	3.719				
R	2.470	2.510		2.494	2.494				
S	0.240	0.270		.258	.258				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.629	1.629				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		0.321	0.321				
X	1.125	1.145		1.1325	1.132				
Y	1.565	1.585		1.5705	1.570				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

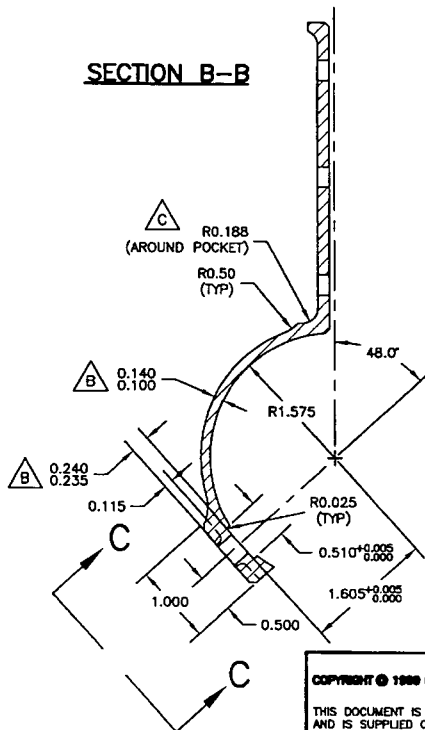
Measured by:	DJP / SF
Date:	08/03/17 08/03/18

Audited by:	ML
Date:	08/03/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2932

SHEET 1 OF 1

SCALE

2:3

RELEASED

07-02-12

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